

Work Order ID 71653

Thursday, July 07, 2011 12:06:25 PM



Page 1

Item ID: D3209-041

Accept



Setup

Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 7/7/2011 Start Qty: 100



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 100



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/07/07

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr	
D3209	Rev A	

100

0.00



BAND SAW

Bandsaw

Memo

0.00

FK- 11/07/07

10 9

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS CNC vertical machine #1

Memo

0.00

Purchasing

Machine D3209-1 as per Folio FA345 and Dwg D3209-1 identify as D3209-1

 Deburr and Tumble

Issue PO 14572
Dm's precision
machine pending D3209 Reut

11/08/07

120

0.00

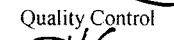


QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00



Receive & Inspect for front damage
Ensure C/SI C attached

FKG

11/07/07 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71653

Thursday, July 07, 2011 12:06:25 PM



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Item ID: D3209-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC Inspect parts - second check

0.00

S u u l o g

(40)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10 8 11-11-8

Memo

0.00

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

10X2 M/F 11/11/08

Memo

0.00

Note: Cover the hole for D3209-1 before powder coat. START TIME: 10:00 OVEN TEMPERATURE: FINISH TIME: 32:00

1530

W118489

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71653

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Thursday, July 07, 2011 12:06:25 PM

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

10 8/11/08

Memo

0.00

161



Small Fab

Memo

0.00

JUL 11/10 O

Small Fab

press fit bushing as per dwg

0.00

170



QC5- Inspect part completeness to step on W/O

0.00

SULU/10

QC

Quality Control

0.00

XO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71653

Thursday, July 07, 2011 12:06:25 PM



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Item ID: D3209-041

Accept



Setup

Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

180



Packaging

Packaging

Identify as per dwg & Stock Location:

ST GA

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

190



QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, July 07, 2011 12:06:22 PM

Work Order ID: 71653



Parent Item: D3209-041



Parent Item Name: Bracket Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A□04.06.09□New issue□KJ/RF□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3209-3		Manufactured	No			100	Each	34.0000	1	6			
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													J. B. 1/1/2010
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Bushing													
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Location	Loc Qty	Loc Code
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ST041	34	
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M6061T6B1.500X01.25	Purchased	No				170	f	20.8278	0.175	1.105263			
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0													10
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6061-T6 Bar 1.50 x 1.25													P.K. - 1/07/20..
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Location	Loc Qty	Loc Code
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MAT004	20.8278	
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													1.625
--	--	--	--	--	--	--	--	--	--	--	--	--	-------

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D3209-1P

X 10

7/7/11 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

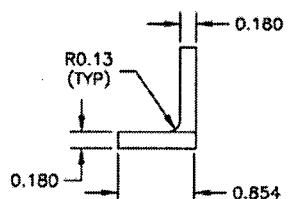
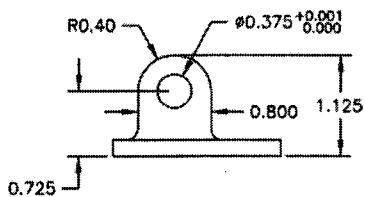
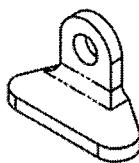
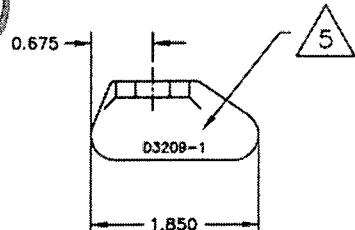
NOTE: Date & initial all entries



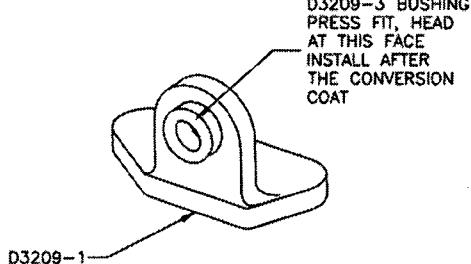
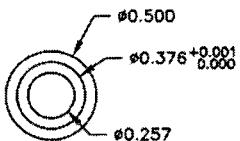
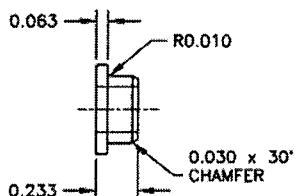
COPIES
CUT

DESIGN RF	DRAWN BY HF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 *[Signature]*



2 D3209-1 BRACKET



3 D3209-3 BUSHING
SCALE 1:2

4 D3209-041 ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71653
C21107107

D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A-3HO
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

PACKING SLIP

Ship To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7

Number: 10919

Date: November 04, 2011

Customer's Order: PO14572

Item #	Line #	Qty	Part #	Description	Status
1	9	10	D3209-1revA	Bracket	Complete
2	10	12	D3911-3revD	AFT Eyebolt Receiver,AFT Hardpoint, Basket	Complete

Number of Packages:

<input type="checkbox"/> Boxes _____
<input type="checkbox"/> Bags _____
<input type="checkbox"/> Bundles _____

Received by: _____ Date: _____

DAN'S PRECISION TOOLS INC.

2550 Devine Road, Vars, ON K0A3H0
Tel:(613) 835-3097 Fax:(613) 835-3760
support@dan's-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 04-Nov-11

Purchase Order : PO14572

Packing Slip : 10919

Part Number : D3209-1revA

Quantity : 10

Sulalog

Per: _____

SJ
For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE LTD.

P.O.: PO14572

W/O: _____

Part #: D3209-041 rev A

Assembly, Bracket

Qty: 10

1 of 1